

Date: Wednesday, 10/3/2007 8:42:30 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 STEP LUG
Job Number	: 34993		
Estimate Number	: 11844		
P.O. Number	: <i>N/A</i>	Part Number	: D23382
This Issue	: 10/3/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2338 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31210	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/20/2007
Checked & Approved By	: <i>[Signature]</i> 07.10.03	Qty:	10
Comment	: Est. B 00.03.24 Separated -1 from -2 EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.3827 f(s)/Unit Total: 3.0618 f(s)  
 6061-T6 Bar .50" x 6.0"  
 Material: 6061-T6 0.5 x 6.0"  
 Batch: *M105145X*  
 1 blank makes one D2338-1 & one D2338-2

*J.L 07/11/13*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut Blanks 8.75" long

*J.L 07/11/13*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per folio D2338  
 Tumble & Deburr

*S.F 07/11/14 (10)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*S.F 07/11/14 (10)*

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*B6 07.11.15 (10)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/11/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:42:30 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 STEP LUG

Job Number: 34993

Part Number: D23382

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~WAPAC~~

*SE 07.11.19* 10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(10) DOLU/R*

Job Completion



*U 07.11.19*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

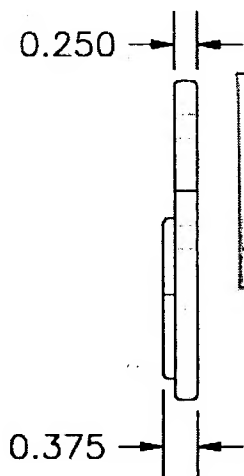
**NOTE:** Date & initial all entries



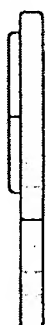
DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2338	SHEET 1 OF 1
DATE	95:01:25	TITLE	ENDPLATE	SCALE	1:2
B	96.03.29	RE-DESIGN AND ADD D2338-2			

RELEASED  
97/04/22 DS

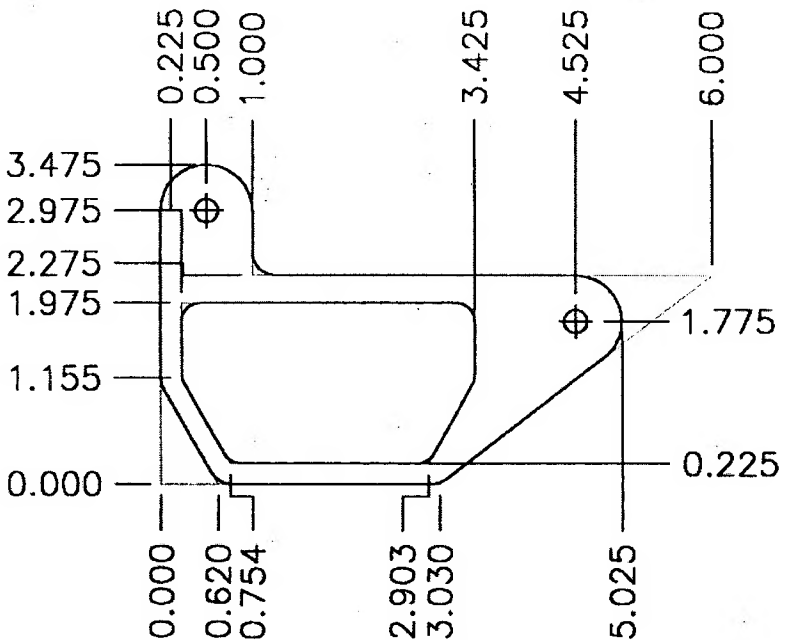
UNDER REVIEW  
02.11.11



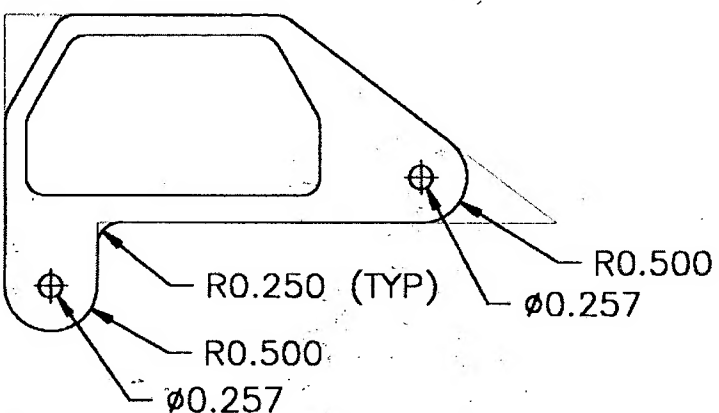
D2338-1



D2338-2



NOTE: BREAK ALL EDGES R0.063 MAX



MATERIAL: 6061-T6, 0.25 THICK

DART AEROSPACE LTD		Work Order: 834993
Description: 204 step lug		Part Number: D233R-2
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.975	$\pm .010$	1.977	✓			
.225	$\pm .010$	.222	✓			
2.275	$\pm .010$	2.279	✓			
3.475	$\pm .010$	3.478	✓			
.225	$\pm .010$	.227	✓			
.500	$\pm .010$	.498	✓			
1.000	$\pm .010$	1.001	✓			
3.425	$\pm .010$	3.428	✓			
4.525	$\pm .010$	4.528	✓			
5.025	$\pm .010$	5.028	✓			
.250	$\pm .010$	.249	✓			
.375	$\pm .010$	.371	✓			
$\varnothing .257$	$\pm .006 - .001$	.262	✓			
R .500	$\pm .010$	.500	✓			
R .250	$\pm .010$	.250	✓			

Measured by: S.F.
Date: 07/11/14

Audited by: RD
Date: 07/11/14

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	